

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013484**Date Inspected:** 28-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

<b>CWI Name:</b>	Mike Johnson		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No
<b>Rod Oven in Use:</b>	Yes	No N/A
<b>Weld Procedures Followed:</b>	Yes	No N/A
<b>Verified Joint Fit-up:</b>	Yes	No N/A
<b>Approved WPS:</b>	Yes	No N/A
<b>Delayed / Cancelled:</b>	Yes	No N/A

**Bridge No:** 34-0006**Component:** Orthotropic Box Girders**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project.

The QAI observed ABF personnel performing a base metal repair of crossbeam connection plate on OBG segment 5E. The QAI noted that the repair is being performed as specified in ABF submittal 1503 rev.15. The QAI noted that the Quality Control (QC) Inspector Mike Johnson is present, is monitoring the welding and inspecting the final repair welds. The QAI noted that Salvador Sandoval, ID 2202, is using shielded metal arc welding (SMAW) with 1/8" E7018 electrodes to make the base metal repair welds. The QAI also noted that welding procedure specification (WPS) ABF-WPS-D15-1000-Repair is being used for the repair. See the attached photos. The QAI noted that after the repair was completed, the weld / base metal was ground smooth and flush. The QAI witnessed the QC Inspector conducting magnetic particle testing on the repair and base metal. The QAI was informed that the weld was completed and acceptable. The QAI made a visual examination of the completed base metal repair and noted that it appears to be generally conforming to the contract requirements. The QAI also observed the shim plates being tack welded onto the bottom of the OBG segments after the repair. This work was in progress until the end of the work shift.

The QAI accompanied Caltrans Office Engineer Victor Altamirano and assisted in performing the post arrival inspection of the Orthotropic Box Girder (OBG) crossbeam #6. The QAI made observations of the interior and exterior surfaces of the crossbeam. There is limited access to view the bottom and top of the crossbeam. The QAI reviewed the shipping / fastening plan and noted where the shoring, longitudinal sea fasteners and lateral sea fasteners made contact with the crossbeam surfaces. The QAI noted that there did not appear to be shipping

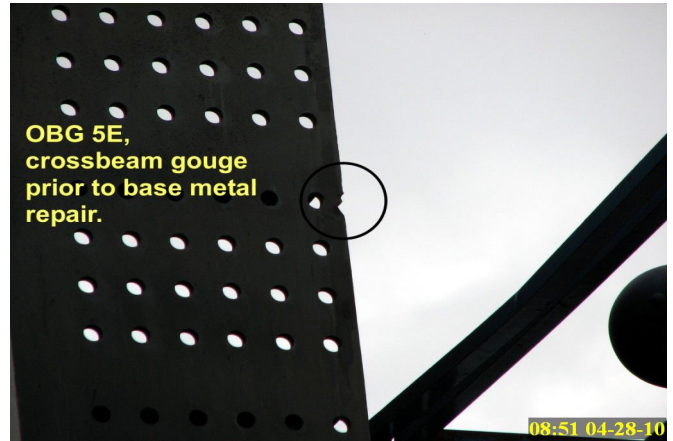
---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

related damage to the crossbeam. See the attached photo. The QAI relayed this information to the QAI Lead Bill Levell.



## Summary of Conversations:

The QAI relayed the above mentioned observations to the QAI Lead Bill Levell. There were no other notable conversations.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi, (916)813-3677, who represents the Office of Structural Materials for your project.

---

**Inspected By:** Croff, Scott

Quality Assurance Inspector

---

**Reviewed By:** Levell, Bill

QA Reviewer

---